

Date: Monday, 11/21/2005 7:41:48 PM  
 User: Linda Lacelle

## Process Sheet

|  |  |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services                   | Drawing Name : 3" OUTER TUBE           |
| Job Number : 24841   |  |
| Estimate Number : 10796  | Part Number : D26001240                |
| P.O. Number : N/A  | Drawing Number : D2600 REV D1          |
| This Issue : 11/21/2005 S.O. No. : N/A                           | Project Number : N/A                   |
| Prsht Rev. : NC  | Drawing Revision : D1                  |
| First Issue : N/A Type : PURCHASED PARTS                         | Material : N/A                         |
| Previous Run : N/A   | Due Date : 12/15/2005 Qty: 50 Um: Each |
| Written By : <u>SEE COMMENT BELOW</u>                            |  |
| Checked & Approved By : <u>SEE ABOVE USER &amp; DATE</u>         |  |
| Comment : Est Rev:A 99.08.18 Was 2600-1 added -240 for length EC |  |

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: PO 00000773

a) Extrude as per Dwg D2600 (240" long)

b) Material: 6061-T6

c) Tool: MH-18870 OK Bowl #897121

d) Material certification is required.

2.0

D26001240

Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Extrusion Round 3" 206

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LB

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

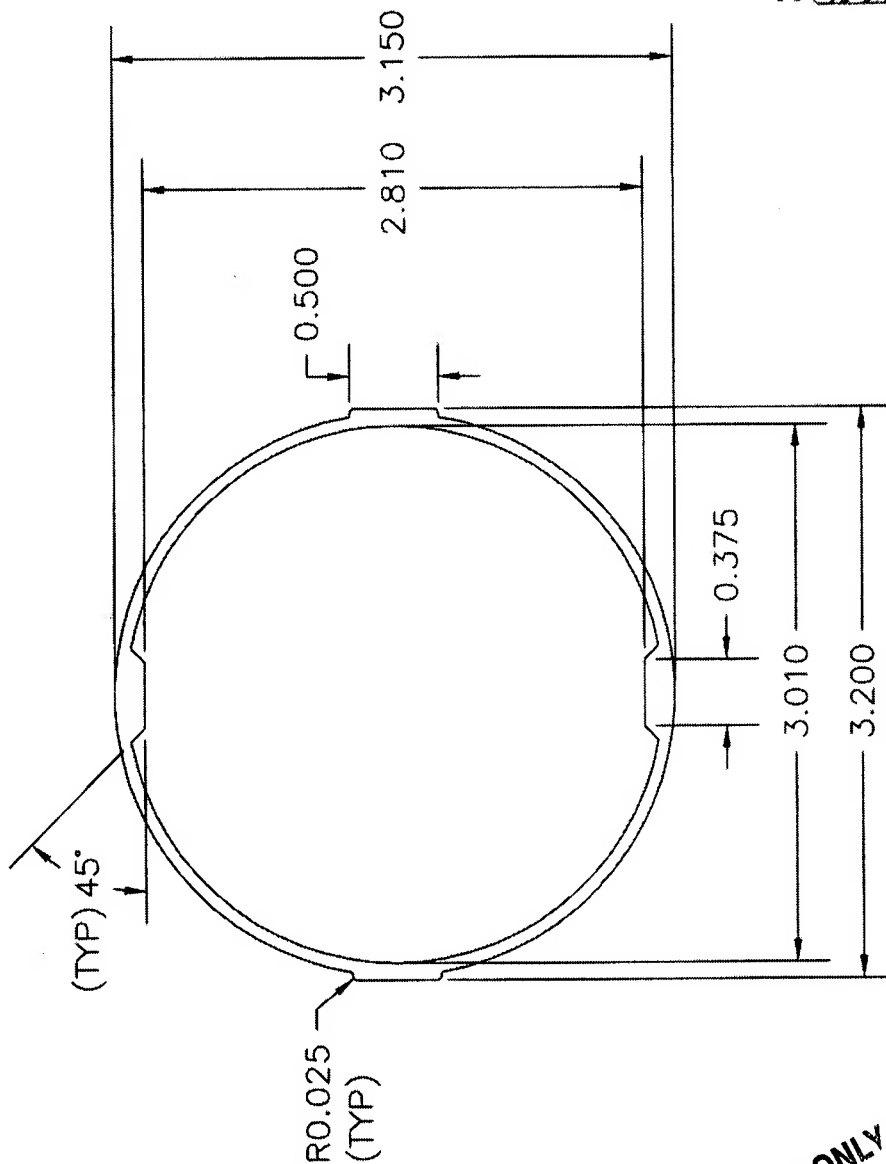
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>DA</i>  | DRAWN BY<br><i>DA</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>KE</i> | APPROVED<br><i>DA</i> | DRAWING NO.<br>D2600                              | REV. D<br>SHEET 2 OF 5 |
| DATE<br>98.08.20     |                       | TITLE<br>EXTRUSION                                | SCALE<br>1:1           |

RELEASED  
98.8.25 DS



REFERENCE ONLY

D2600-1

MANUFACTURED WITH CARADON INDALOX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)





|                              |                                |   |                        |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>[Signature]</i> | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>KE</i>         | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2600                              | REV. D<br>SHEET 1 OF 5 |
| DATE<br>98.08.20             |                                | TITLE<br>EXTRUSION                                | SCALE<br>1:1           |
| A                            | 97.01.21                       | NEW ISSUE   |                        |
| B                            | 97.09.09                       | CHANGE MATERIAL SPEC.                             |                        |
| C                            | 98.04.16                       | ADD D2600-3, UPDATE D2600-1 WIDTH,<br>ADD DIE NO. |                        |
| D                            | 98.08.20                       | INCREASE MIN. UTS TO 40 KSI                       |                        |
| DI                           | 01.04.17                       | ADD PART NUMBERS & DIE NUMBERS <i>FCP</i>         |                        |

RELEASED  
98.08.25 DS

#### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

REFERENCE ONLY

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

|                   |                          |                              |                |
|-------------------|--------------------------|------------------------------|----------------|
| Work Order No     | : 0024841                | Department Code:             |                |
| Project Name      | : D2600-1-240            | Burden Flags                 | : NNNNNNNN     |
| Project For       | : WK550                  | WO Status                    | : Open         |
| Work Order Type   | : Main                   | Invoice State                | : Not Invoiced |
| Main WO Number    | :                        | Invoice Date                 | :              |
| House Part Number | : D2600-1-240            | Invoice Number               | :              |
| Description       | : Extrusion Round 3" 206 | Invoice Amount               | : 0.00         |
| Manufactured      | : Yes                    |                              |                |
| Amount Req'd      | : 50                     | Order Entry No               | :              |
| Amount Done       | : 0                      | OE Value                     | : 0.00         |
| Start Date        | : 11-17-05               |                              |                |
| Est Finish Date   | : 12-20-05               | Est Margin                   | : 0.000%       |
| Act Finish Date   | :                        | Actual Margin                | : 0.000%       |
| Drawings Req'd    | : No                     |                              |                |
| Ok for Approval   | :                        |                              |                |
| Approval Rec'd    | :                        | \$0 Posted to Finished Goods |                |

|                   | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost     | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours | : 0.00    | 0.00   | 0.00   |        |         |
| Engineering Cost  | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours  | : 0.00    | 0.00   | 0.00   |        |         |
| Production Cost   | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours   | : 0.00    | 0.00   | 0.00   |        |         |
| Packaging Cost    | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours    | : 0.00    | 0.00   | 0.00   |        |         |
| OverHead Cost     | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours         | : 0.00    | 0.00   | 0.00   |        |         |
| CNC               | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours       | : 0.00    | 0.00   | 0.00   |        |         |
| Misc.             | : 0.00    | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden            | : 0.00    | 0.00   | 0.00   |        |         |
| Total Cost        | : 0.00    | 0.00   | 0.00   |        |         |
| Margin            | : 0.000   | 0.000  |        |        |         |
| Selling Cost      | : 0.00    | 0.00   |        |        |         |

|                        |           |        |
|------------------------|-----------|--------|
|                        | Estimated | Actual |
| Labour Hrs/Amount Done | : 0.00    | 0.00   |
| Profits/(Loss)         | : 0.00    | 0.00   |

*check BY order*

RM NO. B1065 REV. C  
RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION  
LE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION







# CERTIFICATE OF COMPLIANCE

**BON L CANADA INC**

500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

| Cert Date | Cert No  | Sales Order | Page     |
|-----------|----------|-------------|----------|
| 12/14/05  | 132184   | 78944       | 1        |
| Cust PO   | B/I No   | Lot         | Date     |
| 173       | 00287984 | 78944010    | 12/14/05 |

| Sold To   | Ship To   |
|---|---|
| 48024<br>DART AEROSPACE LTD.<br>1270 ABERDEEN ST.<br>HAWKESBURY, ON K6A 1K7 | 48024<br>DART AEROSPACE LTD.<br>1270 ABERDEEN ST.<br>HAWKESBURY, ON K6A 1K7 |

| Item No      | Part No      | Item Description  | Cust Part      |
|--------------|--------------|-------------------|----------------|
| 1.000        | DAA-897121-2 | 240" Mill 6061 T6 | D2600-1-240    |
| Gross Weight | 605 KGS      |                   |                |
| Net Qty      | 570 KG       | 59 PC             | 360 M<br>1 PKG |

| Specification                 | Die Desc |
|-------------------------------|----------|
| AMS-QQ-A-200/8 & ASTM B221-00 |          |

## Mechanical Tests:

| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend/ Drift HR-E |
|----------|-------------------|-----------------|-------------|--------------|------------------|
| 1        | 320.0 / 46.4      | 291.8 / 42.3    | 14.3        |              | 92               |

## Chemical Analysis:

| SI   | FE   | CU   | MN   | MG   | CR   | NI   | ZN   | GA   | V    | TI   | ZR   | OTHER |
|------|------|------|------|------|------|------|------|------|------|------|------|-------|
| .669 | .306 | .272 | .065 | .905 | .067 | .000 | .121 | .000 | .010 | .017 | .000 | .000  |
| .646 | .276 | .260 | .076 | .863 | .061 | .000 | .013 | .000 | .010 | .017 | .000 | .000  |
| .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000  |
| .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000 | .000  |

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada